



Dart Aerospace Ltd.
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K6A 1K7
Canada

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SWA3-2
Job Sheet 182588



Part No: SWA3-2

Job Qty: 1 ea

Part Name: Electric Swivel 3,000 lb Safe Work Load (1,360 Kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 10/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3 Rev 3

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/23/18	10/23/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs	10/23/18	10/23/18	0.00	2.00	Small Fab-6		
120	QC	1 pcs	10/23/18	10/23/18	0.00	0.00	QC5		
125	DC	1 pcs	10/23/18	10/23/18	0.00	0.00	DC		
130	Packaging	1 pcs	10/23/18	10/23/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea	10/23/18	10/23/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA3 swivel manual*** Engrave Descriptions: T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.
125 - Photocopy blue file OM & OOPM-SWA3A Rev3
130 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-832-3/8	Set Screw	1 Ea (1 ea)	90-Start up Operation	5027242
92210A303	Flat Socket Cap Screw	4 pcs (4 ea)	110-Small Fab	5066762
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5072958
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5054451
EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge	6 ft (6 ea)	110-Small Fab	5047767
SWA3-100 P.	Upper End - Swa3 Swivel	1 Ea (1 ea)	110-Small Fab	5029397
SWA3-200	Lower End	1 Ea (1 ea)	110-Small Fab	505101090
SWA3-300	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5095875
SWA3-400	Button Head Screw	2 Ea (2 ea)	110-Small Fab	5108099
SWA3-500 P	Connector Bushing-230	1 Ea (1 ea)	110-Small Fab	5029461
SWA3-600	O-Ring	1 Ea (1 ea)	110-Small Fab	5097844
SWA3-700	9529K15 Bearing Balls - 1/4"	32 Ea (32 ea)	110-Small Fab	5068311
SWA6A-1900	1/4" Female Spade Connector	4 Ea (4 ea)	110-Small Fab	5073060
SWA6A-900A	Rotary Connector - 2 wire	1 pcs (1 ea)	110-Small Fab	5072695

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-832-3/8	1	63	0
110-Small Fab	92210A303	4	112	0
	EL-PLUG-F	1	33	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

EL-PLUG-M	1	106	0
EL314-SJTOW	6	326	0
SWA3-100	1	0	0
SWA3-200	1	8	0
SWA3-300	2	33	0
SWA3-400	2	22	0
SWA3-500	1	0	0
SWA3-600	1	19	0
SWA3-700	32	1,024	0
SWA6A-1900	4	646	0
SWA6A-900A	1	8	0

Part Specifications

Specifications could not be found.

Loctite 242
Grease Aeroshell
Silicone GE

m138766
m138724
m138942

Plex 8/28/18 2:38 PM Dart.lajeunesse.marie



Container No: S107866



Part: SWA3-2

Job No: 182588

Serial No/Batch: S107866

Revision: 3

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/04/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order 182588

Customer _____

Number of Wires 2Date 18/09/18Serial Number 5107866

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	3,000	Check for Conductivity against all wires.	- Pass
1	3,000	Check all wires for grounding against swivel body.	- Pass
1	1,500	Check for Conductivity against all wires.	- Pass
1	1,500	Check all wires for grounding against swivel body.	- Pass
1	750	Check for Conductivity against all wires.	- Pass
1	750	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By: Francis Lacroix
TechnicianSignature: Sylvie Bouchard
QC 5 Small FAB / QA

Submit